

Date: Friday, 9/21/2007 1:18:44 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 34818		
Estimate Number	: 10827		
P.O. Number	: <i>N/A</i>	Part Number	: D2877
This Issue	: 9/21/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2877 REV B
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: 9/21/2007 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 32104	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	120 Um: Each
Comment	Est B 00.05.19 Added inspect level 8 EC Est C 06.04.26 Water jet EC Est Rev:D Now M6061-T6 06-06-23 JLM Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.5468 sf(s)/Unit Total : 65.6208 sf(s)  
 Material: 6061-T6 (QQ-A-250/8) 0.125" Thick  
 Batch: *M104480* *18 07-09-29*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2877  
 Dwg Rev: *A=B* *18 07-09-28*  
 Prog Rev: *A=B*

2- Tumble *and Debur*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*E 07/10/04* *(121) center*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Tumble  
 Debur any rough edges after tumbling

*[Signature]* *07/10/01* *(121)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DR Date: 07/10/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:45 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 34818

Part Number: D2877

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



121X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*m-h*

07/10/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*CP* 07/10/09 (121)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*CP* 07/10/09 (121)

9.0

QC21

FINAL INSPECTION W/O RELEASE



121

Comment: FINAL INSPECTION W/O RELEASE

07/10/10

Job Completion



*U* 07-10-09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

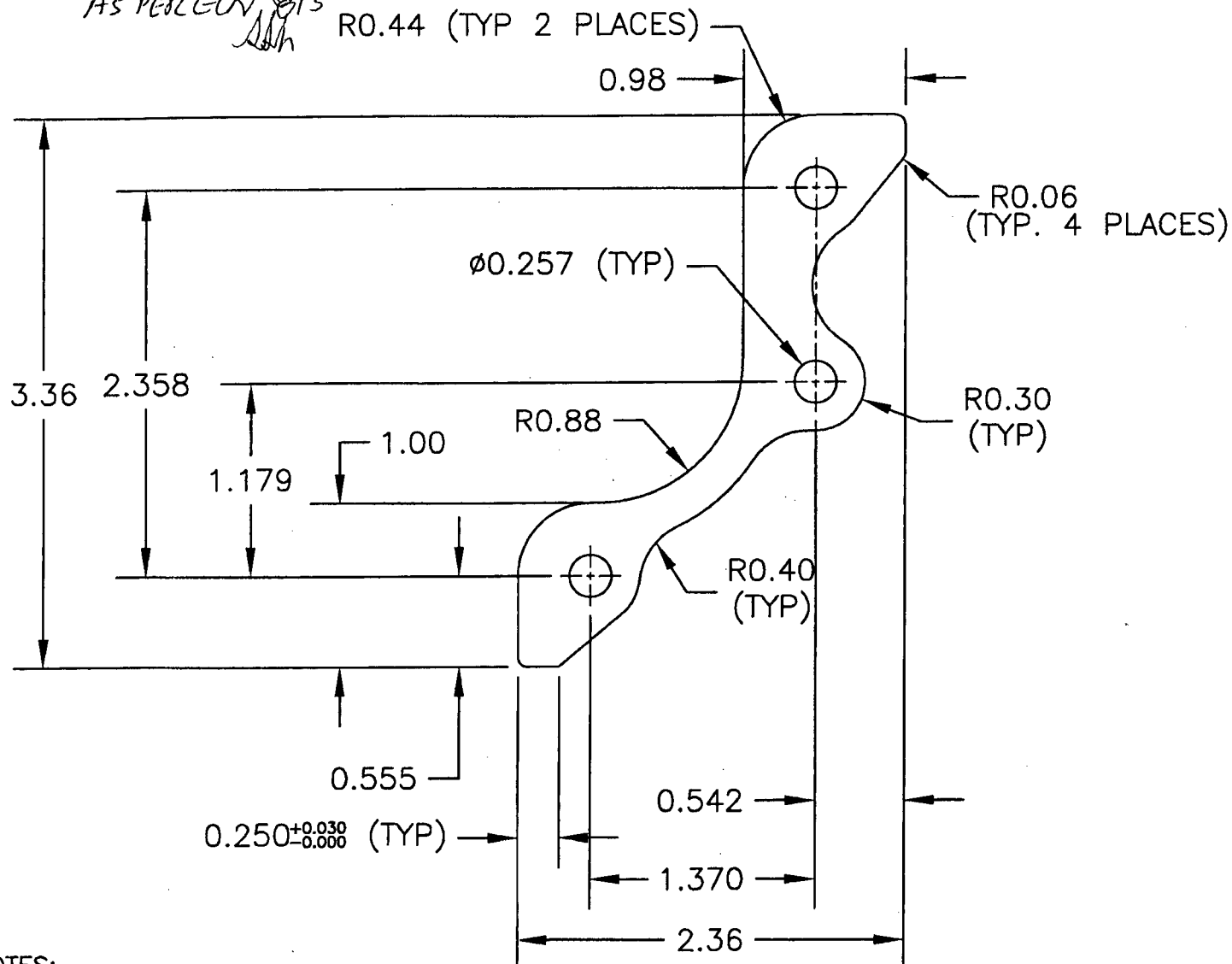
**NOTE:** Date & initial all entries



DESIGN <i>CP</i>		DRAWN BY <i>C.B.</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>		APPROVED <i>[Signature]</i>		DRAWING NO. D2877 REV. B SHEET 1 OF 1	
DATE 06.05.17		TITLE SADDLE SPACER SCALE 1:1			
A	99.02.23	NEW ISSUE			
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE			

RELEASED  
06.06.21

AS PER ECN, §13



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK  
(REF DART SPEC M6061T6S.125)  
OR  
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK  
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34818

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